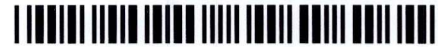




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3204-3
Job Sheet 193700



Part No: D3204-3

Job Qty: 1 pcs

Part Name: Arm



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/20/19

Job Tracking No:

Due Date: 4/16/19

Created By: Julien Charest-Lacombe

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	1 pcs	4/16/19	4/16/19	0.00	0.00	Bandsaw - 1		mm L 19/04/20
110	HAAS 4 Axis - B4B	1 pcs	4/16/19	4/16/19	0.33	0.30	HAAS - 1 - B4B		mm L 19/04/20
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	1 pcs	4/16/19	4/16/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		19/4/20
140	Packaging 3-1 - Stock - B4B	1 pcs	4/16/19	4/16/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		



Container No: S173657



Part: D3204-3

Job No: 193700

Serial No/Batch: S173657

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/20/19

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

				Packaging 3 - 3 - B4B					
				Packaging 3 - 4 - B4B					
				Packaging 3 - 5 - B4B					
				Packaging 3 - 6 - B4B					
				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B	62				
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				150 QC 21 - SA	1 pcs	4/16/19	0.00 0.00	QC 21 - SA - 21	
								QC 21 - SA - 70	
								QC 21 - SA - 53	
Part Op 100 - (Bandsaw) Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Machine as per Folio FA344 and Dwg D3204 Identify as D3204-3 130 - (QC8- Inspect parts - second check) 140 - (Identify as per dwg & Stock Location: _____) LOCATION : WA001-3 150 - (QC21- Final Inspection - Work Order Release)									
Job BOM									
Part / Item	Component Name	Quantity	Operation	Container					
M6061T6B0.500X02.000	6061-T6 Bar .500 X 2.00	.5480 ft (.548 ea)	100-Bandsaw - 1	5008430 X1					
Job Allocations									
Operation	Component Part	Required	Inventory	Allocated					
100-Bandsaw - 1	M6061T6B0.500X02.000	1	25	0					

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	6.000Inches $\pm$ 0.030	6.030 5.970		
2	Arm	5.250Inches $\pm$ 0.030	5.280 5.220		
3	Arm	0.776Inches $\pm$ 0.010	0.786 0.766		
4	Arm	0.760Inches + 0.005 - 0.000	0.765 0.760	Diameter	
5	Arm	0.080Inches $\pm$ 0.010	0.090 0.070		
6	Arm	0.500Inches $\pm$ 0.010	0.510 0.490	Radius	
7	Arm	2.373Inches $\pm$ 0.010	2.383 2.363		
8	Arm	0.750Inches $\pm$ 0.010	0.760 0.740		
9	Arm	0.380Inches $\pm$ 0.010	0.390 0.370	Radius	
10	Arm	0.375Inches + 0.001 - 0.000	0.376 0.375	Diameter	
11	Arm	0.300Inches $\pm$ 0.010	0.310 0.290		

Plex 4/20/19 10:00 AM dart.charest-lacombe.julien